



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

DSK078

Job Sheet 203894



Part No: DSK078

Job Qty: 12 pcs

Part Name: D2893-1 Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/28/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 1/30/20

Description:

Type: Stock

Note: DWG REV A IPP rev A. 08.03.13 new issue EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Doosan - 1	12 pcs	1/30/20	1/30/20	0.50	10.53	Doosan - 1	20/01/02
110	QC 2	12 pcs	1/30/20	1/30/20	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	20/01/02

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S244325



Part: DSK078

Job No: 203894

Serial No/Batch: S244325

Revision:

Inspector:

Exp Date:

Instructions:

Date: 01/02/20

120 QC 8	12 pcs	1/30/20	0.00	0.00	QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	✓ 20-1-06
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130 Packaging 3-1 - Stock - B4B	12 pcs	1/30/20	0.00	0.00	Packaging 3 - 1 - B4B	man 20/01/07
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	

				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	12 pcs	1/30/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - Doosan (Doosan Lathe) Turn blank as per Folio FA081 (4TH AXIS PLUG DT8492) Descriptions: 110 - QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB) 120 - QC8 Machining-4 (QC8- Inspect parts - second check) 130 - Packaging3-2 (Identify as per dwg & Stock Location: _____) LOCATION: MAT060 140 - QC21 (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6104-005	Round Billet, 17-4	12 pcs (1 ea)	100-Doosan - 1	S232866 - H/H/H/c S204681 2	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Doosan - 1	D6104-005	12	29	0	
Part Specifications					
Specifications could not be found.					

Plex 11/28/19 10:06 AM Dart.Renwick.Jennifer

D6104-005
S232866

D6104-005
S204681

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																													
Date :	Sequence #:	QTY Affected :		MRB (QS1042)																													
Description Work Order Deviation		Disposition																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>				Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
		Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																												
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Marks/Chatter	Drill Holes	Out of Sequence	Misread																														
Mislabeled	Fit/Function	Off-set/Set-up																															
Other/Details:																																	
		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____																															

DART AEROSPACE LTD		Work Order:	203894
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.711	2.710	2.707	2.711	2.711
B	4.946	4.966		4.958	4.958	4.958	4.958	4.958
C	3.064	3.084		3.076	3.074	3.073	3.073	3.073
D	0.718	0.738		0.729	0.729	.730	.730	.730
E	0.090	0.110		0.100	.102	.105	.102	.107
F	2.934	2.954		2.9434	2.943	2.945	2.943	2.943
G	2.166	2.186		2.174	2.171	2.174	2.174	2.174
H	3.890	3.910		3.901	3.902	3.901	3.901	3.901
I	0.914	0.934		0.921	0.922	.922	.922	.922
J	0.022	0.042		0.032	.032	.032	.032	.032
K	0.109	0.129		.119	.117	.119	.119	.119
L								
M								
N								
O								
P								

DAS

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Measured by: Justin B.D	Date: 20/01/02
Audited by: JL	Date: 20-01-06
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 203894
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1/6	2/7	3/8	4/9	5/10
Lathe Section								
A	2.707	2.712		2.710	2.711	2.709	2.709	2.709
B	4.946	4.966		4.960	4.960	4.960	4.960	4.960
C	3.064	3.084		3.073	3.073	3.073	3.073	3.072
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.100	.100	.100	.100
F	2.934	2.954		2.942	2.942	2.942	2.942	2.942
G	2.166	2.186		2.176	2.175	2.175	2.175	2.175
H	3.890	3.910		3.899	3.900	3.900	3.899	3.898
I	0.914	0.934		.922	.922	.922	.922	.922
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.116	.115	.117	.117	.117
L								
M								
N								
O								
P								

Measured by: JBW Date: 20-01-07

Audited by: JL Date: 20-01-06

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 203894
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

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				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.710	2.710			
B	4.946	4.966		4.960	4.960			
C	3.064	3.084		3.074	3.073			
D	0.718	0.738		.728	.728			
E	0.090	0.110		.100	.100			
F	2.934	2.954		2.943	2.942			
G	2.166	2.186		2.175	2.175			
H	3.890	3.910		3.901	3.900			
I	0.914	0.934		.922	.922			
J	0.022	0.042		.032	.032			
K	0.109	0.129		.117	.117			
L								
M								
N								
O								
P								

Measured by: JBD	Date: 20-01-07
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